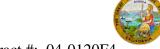
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-016947

Address: 333 Burma Road **Date Inspected:** 06-Sep-2010

City: Oakland, CA 94607

Project Name: SAS Superstructure **OSM Arrival Time:** 700 **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Zhao Chen Sun **CWI Present:** Yes No Yes N/A **Rod Oven in Use:** Yes **Inspected CWI report:** No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No N/A **Verified Joint Fit-up:** Yes No N/A N/A N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No Yes No N/A **Delayed / Cancelled:**

Bridge No: 34-0006 **Component:** Tower & OBG Components

Summary of Items Observed:

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER JETTY

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 25 located on East tower Lift-3, 99 M cross bracing gusset plate to small doubler plate ESD1 – FASA3 – 2B/E. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS -B - P - 4214 - Tc - U4c.

Weld joint # 21 located on North tower Lift-3, 99 M cross bracing gusset plate to small doubler plate NSD1 – FASA3 – 1B/E. Welder is identified as 040582. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS - B - P - 3212- B - U2a - 2.

Weld joint # 28 located on South tower Lift-3, 99 M cross bracing gusset plate to small doubler plate SSD1 – FASA3 – 1B/E. Welder is identified as 057220. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS - B - P - 4212- Tc - U4c - 4.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld joint # 24 located on West tower Lift-3, 99 M cross bracing gusset plate to small doubler plate WSD1 – FASA3 – 2B/E. Welder is identified as 040610. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS -B - P - 3212 - B - U2a - 2.

Weld joint # 24 located on East tower Lift-3, 99 M cross bracing gusset plate to small doubler plate ESD1 – FASA3 – 2B/E. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by OC appeared to comply with the WPS – B – P – 3212– B – U2a – 2.

BAY#10

This QA Inspector observed the following work in progress Shielded Metal Arc Welding (SMAW):

Weld joint # 09 located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3B/F. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS -B - T - 3213 - TC - U4c. (See attached photo)

BAY#11

This QA Inspector observed the following work in progress Shielded Metal Arc Welding (SMAW):

Weld joint # 03 located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4B/F. Welder is identified as 037840. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS -B - T - 3213 - Tc - U4c.

Weld joint # 19 located on East tower Lift-5 Grillage Assembly ESD1 – TL5 – 2B/F. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS -B - T - 3213 - Tc - U4c.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Tack welding of a weld joint # 14 located on Bottom plate BP3093 – 001. Welder is identified as 052641. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS -B - P - 2112 - FCM. (See attached photo)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)





Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer